

Work Order ID 71748

Monday, July 11, 2011 10:01:13 AM

Page 1

Item ID: D212-664-101

Accept

Revision ID: U/R

Item Name: Crosstube Fwd

Start Date: 7/11/2011 Start Qty: 1.00

Required Date: 7/28/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 11-07-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-664-141	Rev D U/R								
100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels as per PPP D212-664-101		CHG004						
110	Pick Kit Packaging	0.00							
Packaging	Memo	0.00							
Packaging									
120	BENDING MACHINE - CROSSTUBES	0.00							
CNC Bend 2	Memo	0.00							
CNC Alpha 160 Bender	Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio D212-664-101								

8 wks/27
CHG005 *SEE ATTACHED
for BG 11-9-26
(4)

JW

11-09-08

JW
SAP

11-09-08

Work Order ID 71748

Monday, July 11, 2011 10:01:13 AM



Page 2

Item ID: D212-664-101

Accept



Setup Start



Revision ID: U/R

Item Name: Crosstube Fwd

Stop



Start Date: 7/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC15- Crosstube Dimensional Check

0.00

SAD 11-09-12

0.00

①

Memo

140



Crosstubes

Crosstubes

Crosstubes

0.00

0.00

Memo

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549, using drill table DT8577, set-up towers in hole #7 as per QSI 10

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

SAD
11-09-12

①

Work Order ID 71748

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Page 3

Item ID: D212-664-101

Accept



Setup Start



Revision ID: U/R

Item Name: Crosstube Fwd

Stop



Start Date: 7/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFXtube	Crosstubes Chemical Conversion	0.00							
Hand Finishing Crosstubes	Memo Chemical Conversion Coat within 24 hours of bending and drilling	0.00	JW/MO			11-09-13			
160 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00	Sulorlig						
170 Outsource2	Outsource process - NDT per QSI038 4.1	0.00							
Outsource process - NDT	Memo Liquid Penetrant Inspection as per QSI 038 Issue P/O: 14914 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	0.00					11-09-14		

Work Order ID 71748

Monday, July 11, 2011 10:01:13 AM



Page 4

Item ID: D212-664-101

Accept



Setup Start



Revision ID: U/R

Item Name: Crosstube Fwd

Stop



Start Date: 7/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Receive & Inspect for Damage & Mat'l Certs Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Ensure copy of NDT results attached to work order.								
190 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Inspect for damage & ensure results are as per Dwg D212-664-141								

Pa 11/11/11 9:11

11 - 09 - 22 ①

Work Order ID 71748

Monday, July 11, 2011 10:01:13 AM



Page 5

Item ID: D212-664-101

Accept



Setup Start



Revision ID: U/R

Item Name: Crosstube Fwd

Stop



Start Date: 7/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00

Customer:

Reference:



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200  SprayPaint	Spray Painting per QSI005 4.2 SprayPaint	0.00				<u>W</u>	<u>11</u>	<u>09 23</u>	<u>①</u>
Spray Painting	Memo 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per DEO D212-667-141 with White Imron as per QSI 005 4.2 PRIME: Start Time: <u>10:00</u> Fininsh Time: <u>11:30</u> <u>> W 11-09-22 ①</u> PAINT: Start Time: <u>11:00</u> Finish Time: <u>12:00</u> <u>> W 11-09-23 ①</u>	0.00							
210  QC	QC14- Inspect Spray Paint	0.00				<u>①</u>	<u>②</u>	<u>11-09-26</u>	
Quality Control	Memo Then, Wrap in plastic bag to protect from scratches	0.00							

W/O: 11/14/8		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.07.12	22	BOND SUPPORTS USING PROSEAL PER ATTACHED PROCEDURE (EMAIL) NOW CHG 005	AM	11 09 26	1	CP 11.07.12 05/042	S 11/09/12

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Chris Provencal

From: David Shepherd <dshepherd@dartaero.com>
Sent: Wednesday, June 15, 2011 3:05 PM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'Dan Stow'; 'Eric Downing'; 'Linda Lacelle'
Subject: RE: Procedure for installing supports.

Follow Up Flag: Follow up
Flag Status: Flagged

Hi Chris,

I agree with your procedure outlined below. It is our preference to leave the paint on the crosstube if we can for added corrosion protection (and for ease of manufacture). If Dan's final testing shows there is a big difference between a painted/unpainted crosstube, then we will switch to alodine only on the crosstube.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Wednesday, June 15, 2011 11:24 AM
To: 'David Shepherd'
Cc: 'Mike Petsche'; 'Dan Stow'; 'Eric Downing'
Subject: RE: Procedure for installing supports.

David,

Can I confirm that this is the agreed procedure for all newly manufactured tubes with off-center supports:

- Scuff paint under support, clean with MEK
- Completely remove any finish on support (if present), scuff bottom surface of support, clean with MEK
- Apply a 0.04" – 0.07" layer of Proseal 890 class B-2 on bottom of support and install wet.
- Install clamps and torque per dwg
- Clean up excess proseal
- Let cure for 72 hours after installation, recheck torque.

Chris

From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: Tuesday, June 14, 2011 10:59 AM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'Dan Stow'; 'Eric Downing'
Subject: RE: Procedure for installing supports.

Made a couple of small changes.

- Remove finish on xtube in area of support down to alodine finish.
- Touch up alodine on xtube in affected area
- Completely remove any finish on support, scuff bottom surface of support
- Apply a 0.04" – 0.07" layer of Proseal 890 class B-2 on bottom of support and install wet.
- Install clamps and torque per dwg



Page 7

Accept

**Setup Start**

Stop

**Cust Item ID:**

Customer:

Reference:

Run Start

Stop

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

QC4- 100% Inspect kits for completeness

0.00

8 ulor 127

[illegible]

QC

Memo

0.00

Quality Control

Packaging

0.00

[illegible]

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D212-664-101

QC21- Final Inspection - Work Order Release

0.00


[illegible]

QC

Memo

0.00

Quality Control

11/9/28 
MF 11-09-28

Picklist Print

Monday, July 11, 2011 10:01:20 AM

Page 1

Work Order ID: 71748

Parent Item: D212-664-101

Parent Item Name: Crosstube Fwd



Start Date: 7/11/2011

Required Date: 7/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E 04.02.16 Reformat KJ/DS
 IPP Rev:F 06-03-29 Remove Coments on Pick List JLM
 IPP Rev:G 07-04-30 As per Rev C JLM IPP Rev:H
 11.04.26 inspection strip ecn 11-549 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D212-664-101TRN Manufactured No



Crosstube Turning Detail

Location

Loc Qty

Loc Code

FG046

2

B72977

71085

1

71086

1

D3595-063-450 Manufactured No



RUBBER CUSHION

230

Each

121.0000

4

4.210526

Location

Loc Qty

Loc Code

LG

121

67353

3

68893

6

70113

32

71354

80

B# 72967

①

SAD

11-09-07

w/ 11-09-26

Picklist Print

Monday, July 11, 2011 10:01:20 AM

Page 2

Work Order ID: 71748

Parent Item: D212-664-101

Parent Item Name: Crosstube Fwd

Start Date: 7/11/2011

Required Date: 7/28/2011

Start Qty: 1.00

Required Qty: 1.00

MS21920-25

Purchased

No

220

Each

136.0000

4

4



Clamp(per MIL-DTL-8783C)



W 11-09-26

Location

Loc Qty

Loc Code

LG

100

113281

0

113282

0

118142

50

118183

50

LG050

36

116264

2

117998

34

D2893-1

Manufactured

No

220

Each

5.0000

2

2



2.75 Support



W 11-09-26

B# 72586

Location

Loc Qty

Loc Code

LG052

5

70736

5

D3428-1

Manufactured

No

240

Each

18.0000

1

1



Placard



11/9/2011

Location

Loc Qty

Loc Code

ST053

18

68920

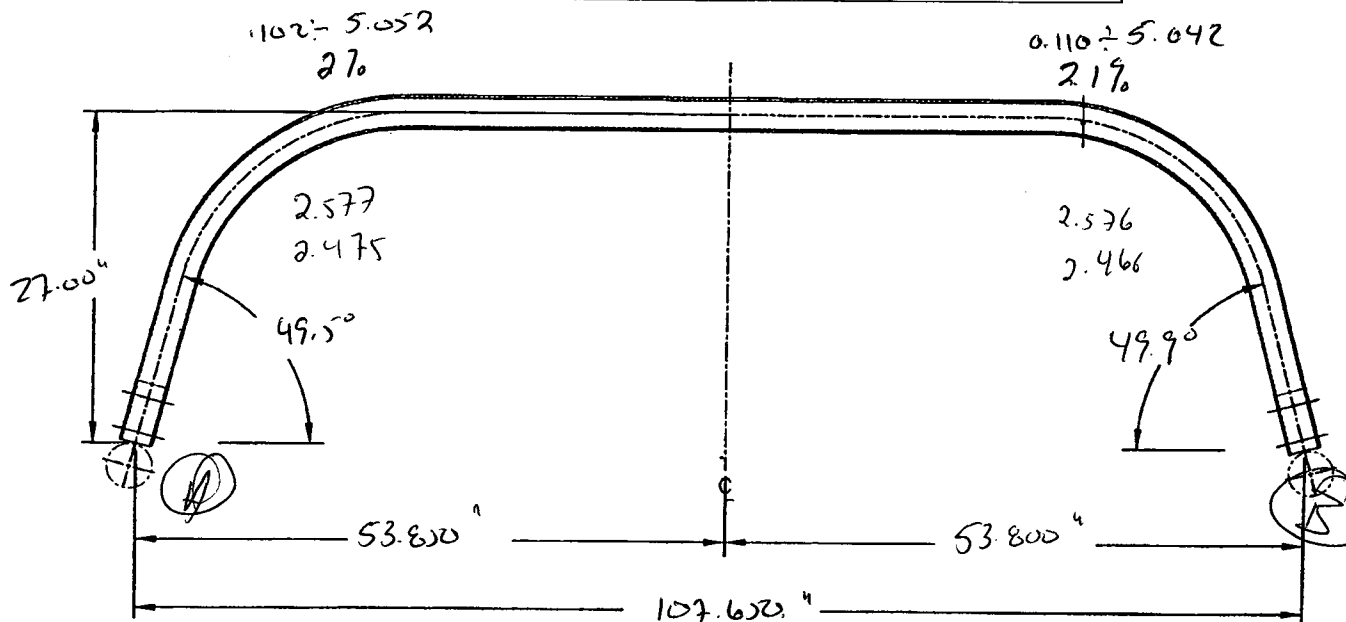
8

71168

10

DART AEROSPACE LTD	Work Order: 7746	
Description: Crosstube High Fwd (205/212/412)	Part Number: D212-664-101	
Inspection Dwg: D212-664-141	Rev: D	Page 1 of 1

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



Comments	
Side A = 2.0% crush	@ 12 Passes
Side B = 2.1% crush	@ 12 Passes

QC15 Inspection	8
Date	10/09/08

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM	
C	10.04.01	Dwg Rev updated	KJ	

D212-664-101 71748 ECLN 11-614

8 7 6 5 4 3 2 1



Item	Qty -141	Qty -141B	Part Number	Description
1	X		D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X	D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3	1	1	D6005-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	4	4	MS21920-25	CLAMP (OR MS21920-26)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF
USING VIBRATING STYLUS
- WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664)
D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS
6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF
D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER
INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE
SUPPORT.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR
DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND
MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT
HAS NOT BOTTOMED-OUT AFTER TORQUING.

REMOVED FROM UNDER REVIEW PER
UNDER REVIEW ECLN 11-614
OF 11/06/15
FOR PRO-SEALING SHORT 11/07/26

DEO ATTACHED

RELEASED
R 2009-10-29
N/A

D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION	BY	DATE

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D212-664-141	SHEET 1 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	XTUBE ASSY (205/212/412 HI FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OTHER THAN FOR WHICH IT WAS ORIGINALLY SUPPLIED WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

12 13 15
D2893-1 SUPPORT
MS21920-25 CLAMP, 2X
D3595-063-450 RUBBER CUSHION, 2X
2 PL

A4-2

A

14.00 (-141)
OR 13.75 (-141B)

D

D212-664-501
BENT TUBE

SYM

D212-664-141/-141B
ASSEMBLY DETAIL

D

CCW 11-614
1.07.20
UNDER REVIEW
11.9.13

DEO ATTACHED

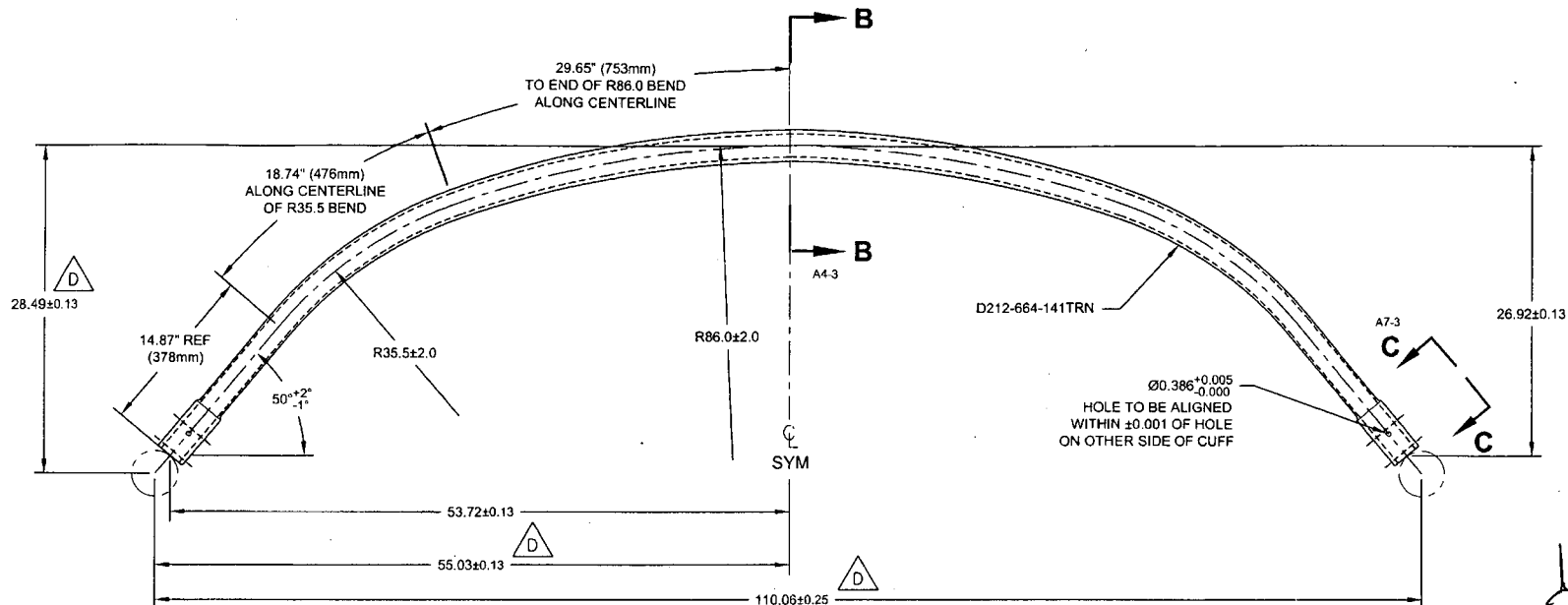
RELEASED
2009-10-29

D2893-1
SUPPORT, REF
12
APPLY MAGNOBOND
BETWEEN D2893-1 AND
CROSSTUBE
D3595-063-450
RUBBER CUSHION
UNDER CLAMP, REF
13 15
MS21920-25
CLAMP, REF

SECTION A-A D5-2
SCALE 4X

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. D
MFG. APPR.	D	D212-664-141	SHEET 2 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	H	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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8 7 6 5 4 3 2 1



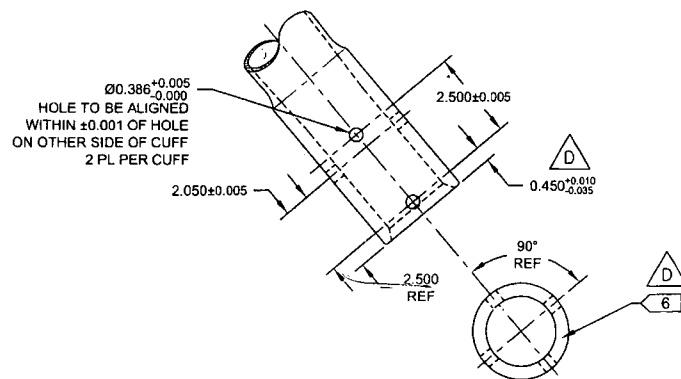
D212-664-501
BENDING AND DRILLING DETAIL



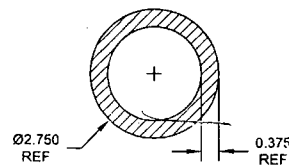
10/11/09
11.09.03
UNDER REVIEW

DEO ATTACHED

RELEASED
2009-10-29

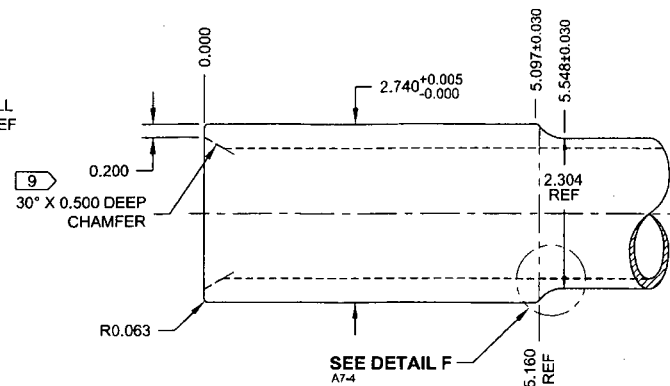
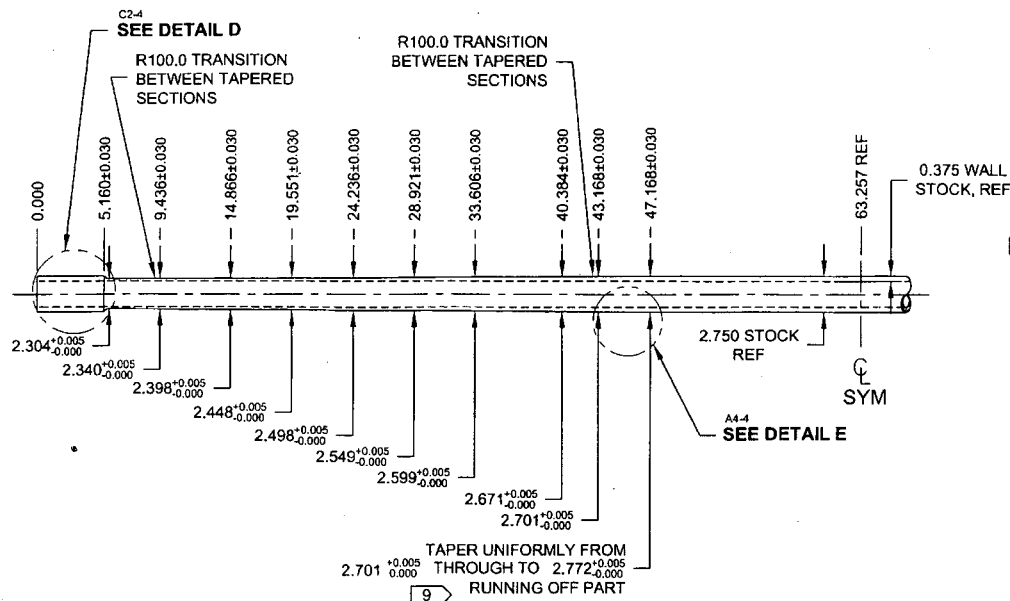


VIEW C-C: CUFF DETAIL
SCALE 3X

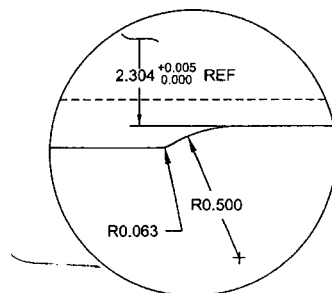


SECTION B-B
SCALE 4X

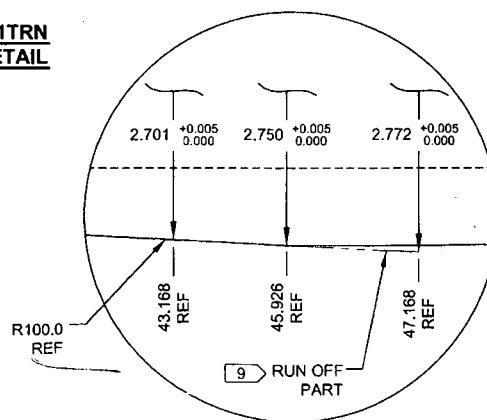
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. D
MFG. APPR.	10	D212-664-141	SHEET 3 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	10	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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DETAIL D:
 CROSSTUBE CUFF D8-4
 SCALE 5X



DETAIL F:
 CUFF TRANSITION C2-4
 SCALE 10X



DETAIL E:
 TAPER RUN-OFF C5-4
 NOT TO SCALE

UNDER REVIEW
 11.06.13

DEO ATTACHED

RELEASED
 2009 -10- 29

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. D
MFG. APPR.	18	D212-664-141	SHEET 4 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	11	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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DRAWING NO. D212-664-141	TITLE XTUBE ASSY (205/212/412 HI FWD)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D212-664-141-D-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN	CHECKED	OP	MFG. APPR.	RE	APPROVED	MP	DE APPR.
DATE 11.04.07	DATE 11.07.11		DATE 11.04.12		DATE 11/09/12		DATE 11.04.12

PURPOSE:

ADD AN INSPECTION WINDOW TO UNDERSIDE OF CROSSTUBE.

CHANGE:

NOTES 2 OF SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND
PAINT OUTSIDE PER DART QSI 005 4.2
REMOVE MASKING AND APPLY CLEAR COAT

WAS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2

RELEASED
2011-04-18

UNDER REVIEW

14/11/06.13
12/05/11-604
11.07.28

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DRAWING NO. D212-664-141	TITLE XTUBE ASSY (205/212/412 HI FWD)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-141-D-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN	CHECKED <i>CP</i>	MFG. APPR. <i>CE</i>	APPROVED <i>WAD</i>	DE APPR. <i>WAD</i>		
DATE 11.04.07	DATE 11.04.11	DATE 11.04.12	DATE 11/04/12	DATE 11.04.12		

IS:



WAS:

UNDER REVIEW

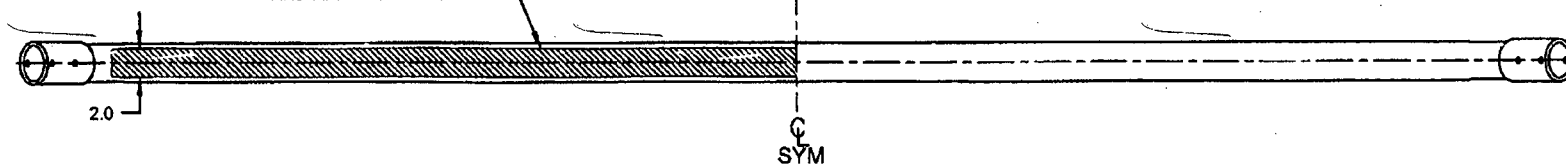
CP 11/06/13

ECN# 11-614
11.07.28

D212-664-501
BENT TUBE

D212-664-141/-141B
ASSEMBLY DETAIL

MASK AREA PRIOR TO PAINTING,
REMOVE MASKING AFTER PAINT
AND APPLY CLEAR COAT



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DRAWING NO. D212-664-141	TITLE CROSSTUBE ASS'Y (205 HI FWD)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D212-664-141-D-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>IP</i>	CHECKED <i>AS</i>	MFG. APPR. <i>AS</i>	APPROVED <i>MP</i>	DE APPR. <i>MP</i>			
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21	DATE 11.07.21			

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -141	Qty -141B	Part Number	Description
7	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

7	A/R	A/R	MAGNOBOND 8398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2893-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28



LIQUID PENETRANT TEST REPORT

P- 12240

PAGE 1 OF 1

CLIENT DART Aero Space DATE SEPT 10 2011 TIME AM ☒ PM ☐
ATTENTION LINDA LACELLE ACUREN JOB NO. 188-11-02359
ADDRESS 1270 ABERDEEN ST. POWO No. 14914
HAWKES BURY ON T. WORK LOCATION HAWKES BURY
PROJECT F.P. I. on CROSS TUBES ACCEPTANCE STD ASTM 1417/BSI REV/DATE 2005
ITEM(S) EXAMINED (8)

JOB DESCRIPTION PROCEDURE NO. LT-002 REV/DATE 2008 TECHNIQUE NO. LT-1042 REV/DATE 2008

PART NO. - MATERIAL ALUMINUM THICKNESS -

SCOPE WET FLOUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT ON 100% EXTERNAL SURFACE.

TEST DETAILS

METHOD <input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND <u>UTENA FULLX</u>	BLACK LIGHT S/N <u>16459</u> <input checked="" type="checkbox"/> OUTPUT > 1000 μ W/cm ² <input type="checkbox"/> AMBIENT < 2 fc
PENETRANT <u>2LB7</u> MINIMUM DWELL TIME <u>45</u> MIN.	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER <u>H2O</u> MINIMUM DRY TIME <u>>10</u> MIN.	OTHER
DEVELOPER <u>SKD52</u> MINIMUM DWELL TIME <u>10</u> MIN.	LIGHT METER S/N <u>1098866</u> CAL DUE DATE <u>FEB-07-2012</u>
DEVELOPER TYPE <input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY	

TEST SURFACE

SURFACE CONDITION <input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input checked="" type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE <input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F <input checked="" type="checkbox"/> 10°C/50°F TO 52°C/125°F <input type="checkbox"/> > 52°C/125°F

RESULTS- ☒ METRIC ☐ IMPERIAL

1	CROSS TUBE - W.O.	71747	✓
1	CROSS TUBE - W.O.	73043	✓
1	CROSS TUBE - W.O.	73044	✓
1	CROSS TUBE - W.O.	71748	✓
1	CROSS TUBE - W.O.	77971	✓
1	CROSS TUBE - W.O.	77970	✓
1	CROSS TUBE - W.O.	71376	✓
1	CROSS TUBE - W.O.	71375	✓

11.09.22

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE <u>Ian Titley</u> PRINT	<u>Ian Titley</u> SIGNATURE	DTR # <u>E-63683</u>
TECHNICIAN (SIGNATURE): <u>Mike Johnston</u>		REPORT REVIEWED BY: <u>-</u>
NAME (PRINT): <u>Mike Johnston</u>		NAME INITIALS
CGSB LEVEL <u>II</u> SNT LEVEL <u>II</u>	CGSB LEVEL <u>-</u> SNT LEVEL <u>-</u>	
CGSB REG. No <u>0606</u>	CGSB REG. No <u>-</u>	